

Work Order ID 55816

Tuesday, February 02, 2010 1:24:59 PM

Page 1

Item ID: D3463-1

Accept

Setup Start

Revision ID:

Item Name: Arm

Stop

Start Date: 2/3/2010 Start Qty: 8.00

Required Date: 2/12/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 10-2-2

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3463

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 25.00 " long

⇒ m-l 10/02/03

24X

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Bend as per dwg D3463-2-Trim to length per dwg D3463-3- Deburr

⇒ m-l 10/02/03

24X

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Ensure 90 deg angle is within tol. (+/-0.5deg) critical dim.

⇒ Sideloy

*located
x24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3463-1 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: 2 Date: 10-02-11
 Resolution: A & B re-work Disposition: A & B re-work QA: N/C Closed: 10/02/11 Date: 10/02/11

NCR: <u>55816</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/02/07</u>	<u>130</u>	<u>One hole diameter is oversized by .025"</u> <u>R.C. Tly too drill with and mill too save some time.</u>	<u>[Signature]</u>	<u>Fill hole with weld per Q37004</u>	<u>LB</u> <u>10/02/07</u> <u>[Signature]</u> <u>10/02/08</u>	<u>S</u> <u>10/02/07</u>	<u>[Signature]</u>	<u>S</u> <u>10/02/08</u>
<u>10/02/07</u>	<u>130</u>	<u>One part the distance of .435^{+0.015} - .000 is off by .100"</u> <u>R.C. Set-up part operator forgot to edge finder.</u> <u>R.C. Lack of attention.</u>	<u>[Signature]</u>	<u>Fill hole with weld per Q37004</u>	<u>LB</u> <u>10/02/07</u> <u>[Signature]</u> <u>10/02/08</u>	<u>S</u> <u>10/02/07</u>	<u>[Signature]</u>	<u>S</u> <u>10/02/08</u>

NOTE: Date & initial all entries

Work Order ID 55816

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Item ID: D3463-1

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Revision ID:

Item Name: Arm

Start Date: 2/3/2010 Start Qty: 6.00

Required Date: 2/12/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1- Drill as per dwg D3463 2-Deburr as per dwg D3463

S.F. 10/02/06

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

S.F. 10/02/06

150

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

⇒ S.F. 10/02/09

(X24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Start Date: 2/3/2010 Start Qty: 6.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: WA025A 0.00

Packaging

Memo

0.00

Packaging

(24x)

Cpl 10/02/09

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/11

MF 10-2-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, February 02, 2010 1:24:58 PM

Page 1

Work Order ID: 55816



Parent Item: D3463-1



Parent Item Name: Arm

Start Date: 2/3/2010

Required Date: 2/12/2010

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M316TR1.00W.120

Purchased

No

100

f

98.0000

13.1558



316 RD tubing 1.00 x .120w

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

98

111096

98

10/02/02

24X m-l

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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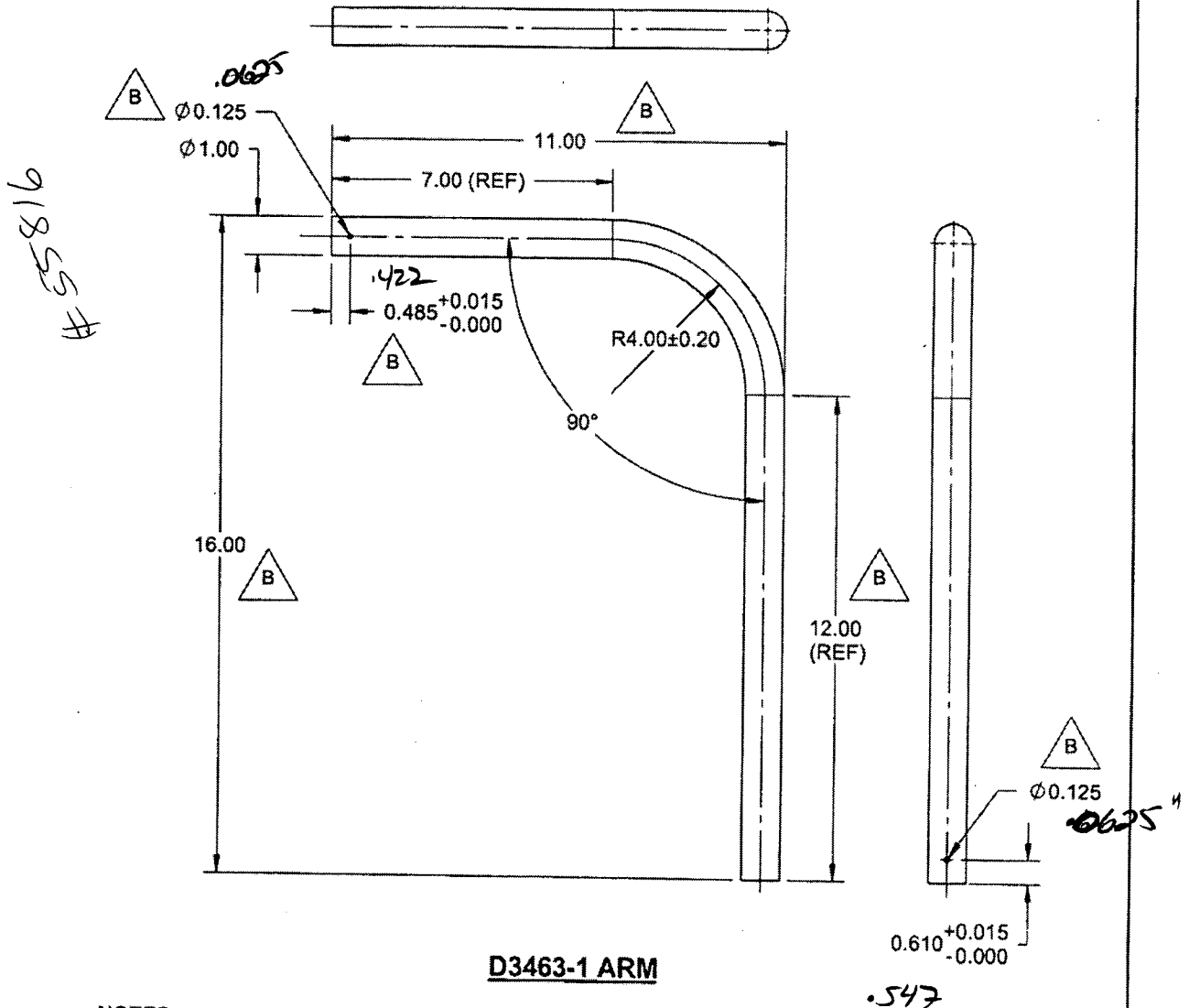
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED05.12.09 *[Signature]***D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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